



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
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Reprint

RBW6005G00131-3G

Job Sheet 183515



Part No: RBW6005G00131-3G

Job Qty: 1 ea

Part Name: Multi-Purpose Trolley



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/19/18

Job Tracking No:

Due Date: 11/20/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: IPP Rev A 17.11.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		11/20/18	0.00	0.00	Purchasing		<i>done on previous order.</i>
110	Packaging	1 pcs		11/20/18	0.00	0.00	Packaging2		
120	QC	1 pcs		11/20/18	0.00	0.00	QC6		
121	Small Fab - 2 - B4B	1 pcs		11/20/18	0.00	0.00	Small Fab - 1 - B4B	<i>2,3,4,5, MLC</i>	
122	QC 5	1 pcs		11/20/18	0.00	0.00	QC 5		<i>38</i>
130	Packaging	1 pcs		11/20/18	0.00	0.00	Packaging3		<i>2-89</i>
140	QC21-FG	1 Ea		11/20/18	0.00	0.00	QC21		<i>NOV 22 2018</i>

Part Op 100 - Issue P/O: _____ MANUFACTURE RBW6005G00131-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

121 - 1-Engrave placard RB41011 using MARKTRONIC engraver. 2-Transfer drill placard as per DWG.. 3-Deburr as required. 4-Install placard using #2 drive screws. 5-Install sticker as per DWG.

130 - Fabricate crate as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6005G00131-3GP	Multi-Purpose Trolley	1 pcs (1 ea)	100-Purchasing	
90081A077	Drive Screw #2 1/4" Long	4 Ea (4 ea)	121-Small Fab - 2 - B4B	<i>304890</i>
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	121-Small Fab - 2 - B4B	<i>3021040</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6005G00131-3GP	1	0	0
121-Small Fab - 2 - B4B	90081A077	4	88	0
	RB41011	1	701	0

Part Specifications

Specifications could not be found.

Plex 11/21/18 1:32 PM dart.white.jesse



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RBW6005G00131-3G

Job Sheet 183515



Part No: RBW6005G00131-3G

Job Qty: 1 ea

Part Name: Multi-Purpose Trolley



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/19/18

Job Tracking No:

Due Date: 10/23/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: IPP Rev A 17.11.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	10/23/18	10/23/18	0.00	0.00	Purchasing		NOV 21 2018
110	Packaging	1 pcs	10/23/18	10/23/18	0.00	0.00	Packaging2		NOV 21 2018
120	QC	1 pcs	10/23/18	10/23/18	0.00	0.00	QC6		NOV 21 2018
130	Packaging	1 pcs	10/23/18	10/23/18	0.00	0.00	Packaging3		9-89
140	QC21-FG	1 Ea	10/23/18	10/23/18	0.00	0.00	QC21		

Part Op 100 - Issue P/O: 041059 MANUFACTURE RBW6005G00131-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

SEPT 18. 2018 x 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6005G00131-3GP	Multi-Purpose Trolley	1 pcs (1 ea)	100-Purchasing	5129762

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6005G00131-3GP	1	1	0

Part Specifications

Specifications could not be found.

Plex 9/19/18 10:30 AM dart.Lussier.Patrick



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Container No: S129763



Part: RBW6005G00131-3G

Job No: 183515

Serial No/Batch: S129763

Revision: 4 U/R

Inspector:

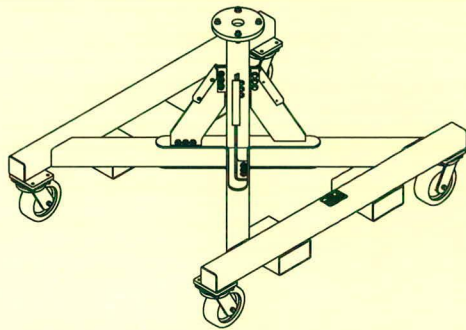
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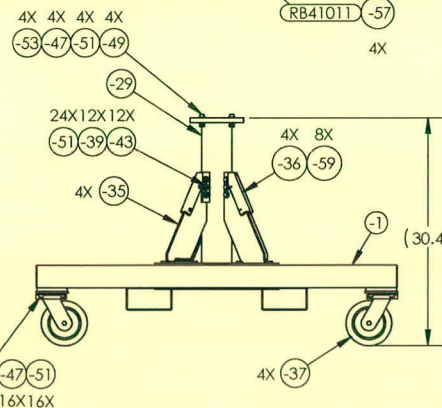
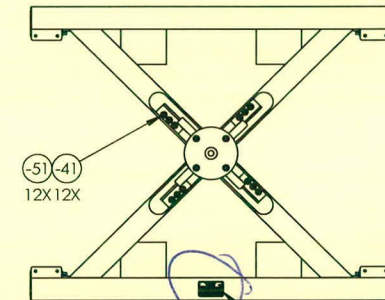
Date: 11/21/18

NOV 5 1988
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9-88

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
A		ADDED -3G TO END OF TOOL NUMBER.	11/16/2009	RJC	RW	
1		LABELLED -11 & CHD 5.875 TO 5.87 P/N -1 WELDMENT, CHD -13 FROM .437 TO .500 THICKNESS, CHD HOLES FROM Ø.562 TO Ø.750 P/N -5 & -7, DELETED Ø.437 (H4) HOLES FROM P/N -3, CHD THREADED HOLES FROM Ø.500 TO Ø.530 THROUGH HOLES P/N -19, CHD SOME DIMENSIONS FROM 3 TO 2 DECIMAL PLACES P/N -19, -23, & -25, CHD DIMENSION 12.000 TO 12 P/N -25 PER D.W.	8/17/2010	RJC	DW	
2		CHD -1 WELDMENT TO INCLUDE -3 AND -11 WELDMENTS, ADDED -3 WELDMENT & 12X 3/8-16 HOLES TO PREVENT FINISH PROBLEMS, DELETED -5 Ø.797 THRU ONE WALL HOLE, CHD -9 DESIGN TO MAKE LIGHTER AND COLLAPSIBLE & DELETED -11 CONFIGURATION OF -9, MADE SEPARATE -11 WELDMENT, CHD -23 HOLE FROM Ø.797, CHD -25 DESIGN, ADDED Ø.723 +.000-.002 FEATURE TO SLIP FIT -23 FOR PLUG WELD, CHD -33 OVERALL LENGTH FROM 5.280 AND ADJUSTED HOLE PLACEMENT, REDESIGNED -35 GUSSET TO BE COLLAPSIBLE.	1/17/2013	RJC	DW	
2A		-35 CHD DIM. SCHEME CORRECTED MODEL PER G.E. CHD DIM WAS 4.00 IS 4.14.	4/1/2013	BIM	GE	
3		-31 CHD OD WAS Ø6.850 IS Ø7.0000, CHD BOLT CIRCLE WAS Ø5.375 IS Ø5.512, CHD CENTER HOLE WAS Ø4.560 IS Ø1.575.	7/10/2013	RJC	DW	
4		-9 CHD HOLE FOR POWDER COATING CLEARANCE WAS Ø.797 IS Ø.81, -21 REMOVED NOTE TO TAPE BEFORE POWDER COAT. -15 & -23 CHD DIM. PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS. -31 WAS (Ø7.000) IS Ø7.00. -35 ADDED DIM 6X .812 FOR LENGTH OF SLOTS, CHD SLOT WIDTH DIM. WAS 3X .406 IS 6X .406.	10/10/2013	CFS	GE	
5	17-0072	UPDATED TO NEW STANDARDS, CHD DIM WAS 30.4 IS (30.4) -1, -3, -5, -7, -9, -11, -13, -15, -17, -19, -21, -23, -27, -29, -33, -35 CHD TOL. WAS .XXX±.005/.XXX±.01 IS .XXX±.010/.XXX±.03, -1 ADDED NOTE Δ, -3 CHD DIM WAS 3/8-16 UNC W .75 IS 3/8-16 UNC-28 W .75, WAS 8.030 IS 4X 8.030, WAS 7.030 IS 4X 7.030, WAS 6.030 IS 4X 6.030, WAS .750 IS 12X .750, -5, -7, -13, -29 CHD DIM WAS (.188) IS .19, WAS (3.00) IS 3.00, WAS (3.00) IS 3.00, -9, -23 CHD DIM WAS (.250) IS .25, -11 CHD DIM WAS (.118) IS (.118), REMOVED DIM 4.00, -15 CHD DIM WAS (.06) IS .07, -17 CHD DIM WAS 4X 3/8-16 UNC THRU IS 4X 3/8-16 UNC-28 THRU, WAS (Ø.50) IS Ø.50, CHD MATL WAS 1018 IS 1018/1020 CR, -19 CHD DIM WAS (3.00) IS 3.00, WAS (4.00) IS 5.00, WAS (.120) IS .12, -25 CHD MATL WAS 1081 IS 1018/1020 CR, CHD DIM WAS .480 IS .48, -27 CHD DIM WAS (.13) IS (.13), -31 CHD DIM WAS (.625) IS .63, -33 CHD DIM WAS (.250) IS .25, -35 CHD DIM WAS (.250) ADDED DIM 6X FULL R, REMOVED DIM (.250); CHD MATL WAS A36 P&O IS A36/1018/1020 HR, -34 ADDED.	3/23/2017	SM	JAG	



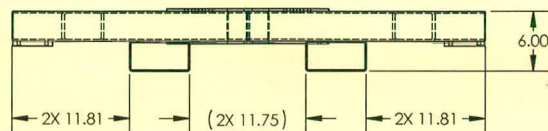
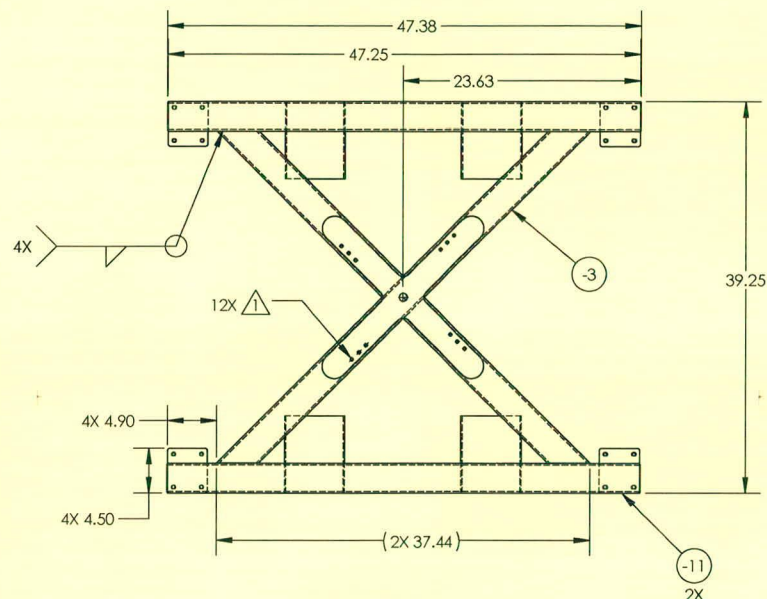
SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MULTI-PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G	REV 5
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ± 1/16 DECIMALS ± .01 ANGLES ± .5° SURFACES ± 125
CHECKED BY: CLOUGH	1. BREAK ALL SHARP EDGES 0.15 x 45° OR .015R
CHECKED: DD 03/23/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/24/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/25/2017	AW139
SCALE: 1:12	DATE: 12/10/2012
SHEET 1 OF 20	

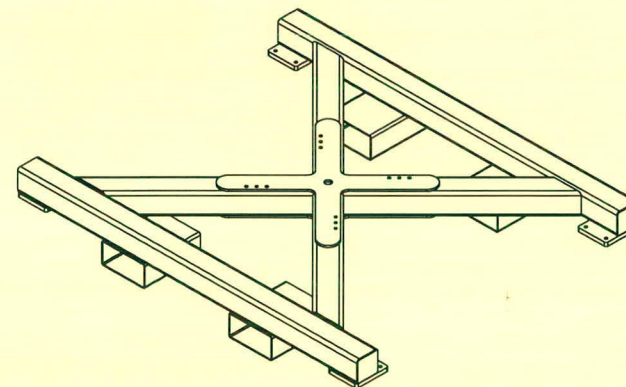
ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			X		-1	1	FRAME WELDMENT			2
		X	1		-3		CENTER TUBE WELDMENT			3
		1			-5		LONG CENTER TUBE	STEEL		4
		2			-7		CENTER SHORT TUBE	STEEL		5
		2			-9		DOUBLER PLATE	A36/1018/1020 HR		6
	X		2		-11		SIDE WELDMENT			7
	1				-13		SIDE TUBE	STEEL		8
	2				-15		END CAP	STEEL		9
	2				-17		WHEEL PLATE	1018/1020 CR		10
	2				-19		FORK TUBE	STEEL		11
1	X				-21		ALIGNMENT PLATE WELDMENT			12
1					-23		ALIGNMENT PLATE			13
1					-25		ALIGNMENT PIN	1018/1020 CR		14
X					-27	1	UPRIGHT WELDMENT			15
1					-29		VERTICAL TUBE	STEEL		16
1					-31		TOP PLATE	A36/1018/1020 HR		17
4					-33		PLATE	1018/1020 CR		18
					-35	4	GUSSET	A36/1018/1020 HR		19
					-36	4	PROTECTOR	WHITE DELRIN/ACETAL		20
				B/O	-37	4	6in. LOCKING SWIVEL WHEELS W/BRAKES	APPLIED (BASICK #CAS60156Y200A81 BG 5L BK W/BRAKES)		1
				B/O	-39	12	HEX HEAD CAP SCREW	STEEL 3/8-16 X 1-1/4 (MCMASTER-CARR #92620A626)		1
				B/O	-41	12	HEX HEAD CAP SCREW	STEEL 3/8-16 X 3/4 (MCMASTER-CARR # 92620A622)		1
				B/O	-43	12	NYLON INSERT HEX NUT	STEEL 3/8-16 (MCMASTER-CARR #97135A230)		1
				B/O	-45	16	SOCKET HEAD CAP SCREW	STEEL 3/8-16 UNC X 7/8 (MCMASTER-CARR # 91251A623)		1
				B/O	-47	20	LOCK WASHER	STEEL Ø3/8 (MCMASTER-CARR #90073A231)		1
				B/O	-51	56	FLAT WASHER	STEEL Ø3/8 (MCMASTER-CARR # 90126A031)		1
				B/O	-49	4	SOCKET HEAD CAP SCREW	STEEL 3/8-16 UNC X 1-1/4 (MCMASTER-CARR #91251A626)		1
				B/O	-53	4	HEX NUT	STEEL 3/8-16 UNC (MCMASTER-CARR #94191A300)		1
				B/O	-57	4	#2 DRIVE SCREW	COATED STEEL #2 X 1/4 (MCMASTER-CARR #90081A077)		1
				B/O	-59	8	FLAT HEAD SOCKET CAP SCREW	S.S. #12-24 x 1" (MCMASTER-CARR # 92210A028)		1
				B/O		1	DART PLACARD	ALUMINUM RB41011		1
				B/O		1	CRATE	CRATE (id) 56 X 42 X 14, ISPM15 CERTIFIED HT.		N/S
ASSY 27	ASSY 21	ASSY 11	ASSY 3	ASSY 1						

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		CHD -1 WELDMENT TO INCLUDE -3 AND -11 WELDMENTS.	1/17/2013	RJC	DW
5	17-0072	-1 ADDED NOTE Δ ; CHD TOL WAS .XXX $\pm$.005/.XX $\pm$.01 IS .XXX $\pm$.010/.XX $\pm$.03.	3/23/2017	SM	JAG



(-1)
FRAME WELDMENT



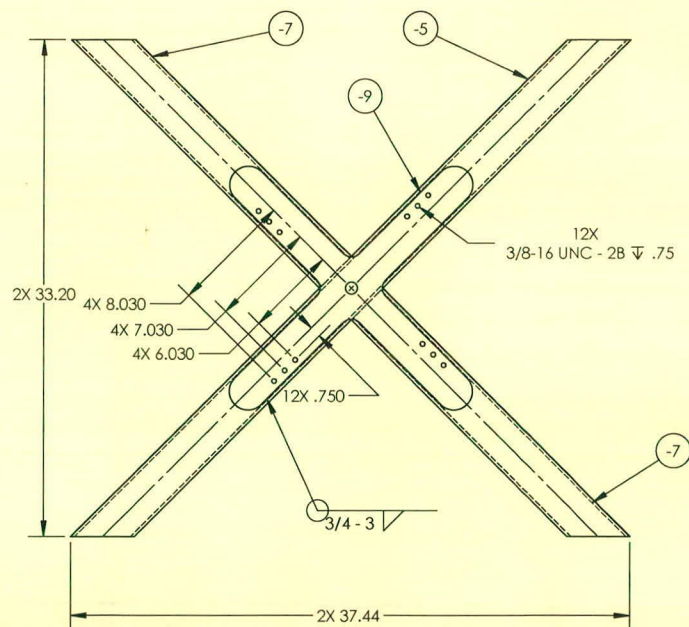
SEE ATTACHED DEVIATION

NOTE:
 Δ NO POWDER COAT ON THREADS.

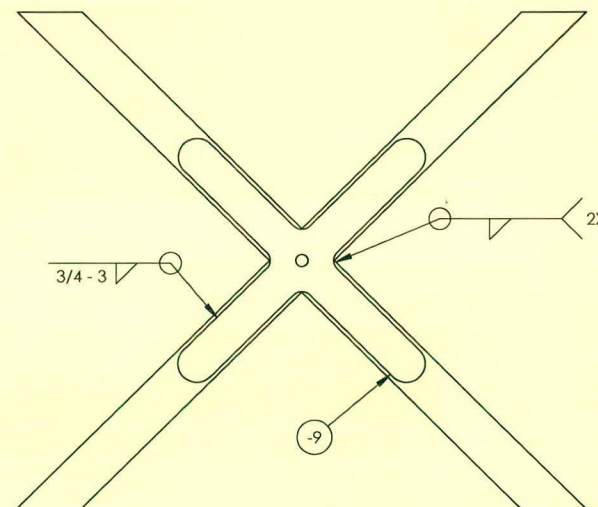
DART AEROSPACE	
TITLE MULTI-PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-1	REV 5
MAT'L TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.010 FRACTIONS $\pm$ 1/8 .XX $\pm$.03 ANGLES $\pm$ 1° X $\pm$.1 SURFACES $\pm$ 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH CHECKED: DD 03/23/2017 CIPPS APPR: AA 07/24/2017 QA APPR: JL 07/24/2017 APPROVED: JAG 07/25/2017	
USED ON MODEL AW139	
SCALE 1:12	DATE 12/10/2012
SHEET 2 OF 20	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2		ADDED -3 WELDMENT & 12X 3/8-16 HOLES TO PREVENT FINISH PROBLEMS.	1/17/2013	RJC
5	17-0072	-3 CHD DIM WAS 3/8-16 UNC Ψ .75 IS 3/8-16 UNC-2B Ψ .75, WAS 8.030 IS 4X 8.030, WAS 7.030 IS 4X 7.030, WAS 6.030 IS 4X 6.030, WAS .750 IS 12X .750; CHD TOL WAS .XXX $\pm$.005/.XXX $\pm$.01 IS .XXX $\pm$.010/.XXX $\pm$.03.	3/23/2017	SM
				DW
				JAG



-3
FRAME WELDMENT



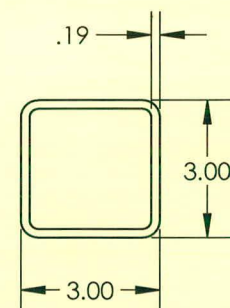
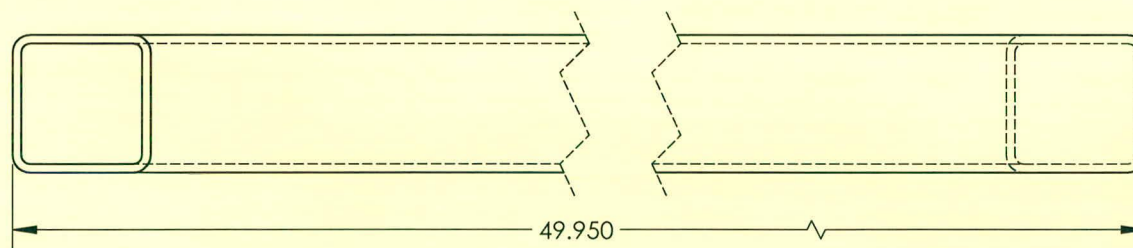
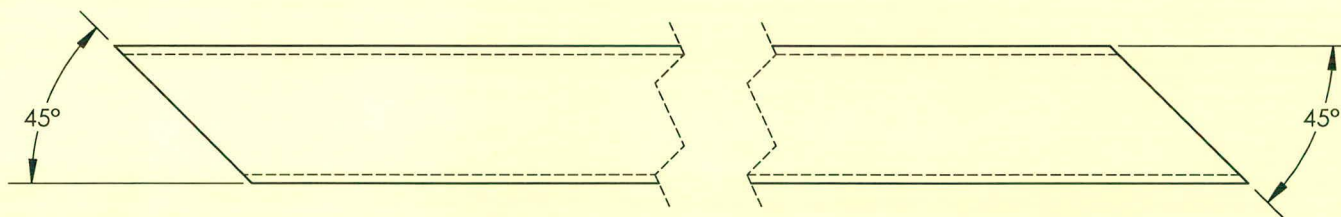
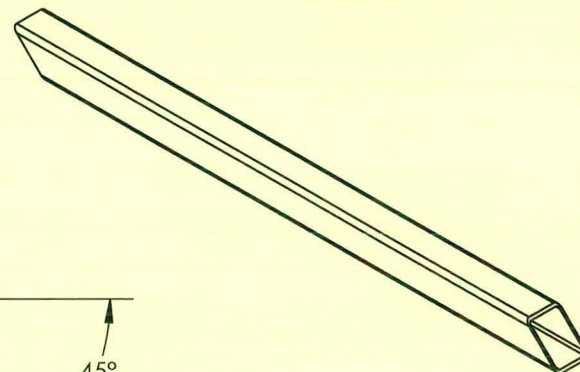
HIDDEN LINES REMOVED

SEE ATTACHED DEVIATION

		TITLE	
		MULTI-PURPOSE TROLLEY	
DWG NO.		REV	
RBW6005G00131-3G-3		5	
MATERIAL		UNLESS OTHERWISE SPECIFIED	
FINISH SEE -1 WELDMENT		DIMENSIONS ARE IN INCHES	
		.XXX $\pm$.010 FRACTIONS $\pm$ 1/8	
		.XX $\pm$.03 ANGLES $\pm$ 1°	
		.X $\pm$.1 SURFACES $\pm$ 125°	
SPEC		1. BREAK ALL SHARP EDGES	
DRAWN BY: CLOUGH		.015 x 45° OR .015R	
CHECKED: DD 03/23/2017		2. DIMENSIONAL LIMITS APPLY	
OPPS APPR: AA 07/24/2017		AFTER PLATING	
QA APPR: JL 07/24/2017		3. INTERPRET DIM AND TOL PER	
APPROVED: JAG 07/25/2017		ASME Y14.5M-2009	
		USED ON MODEL	
		AW139	
SCALE	1:8	DATE	12/10/2012
		SHEET 3 OF 20	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		DELETED -5 Ø.797 THRU ONE WALL HOLE	1/17/2013	RJC	DW
5	17-0072	-5 CH'D DIM WAS (.188) IS .19, WAS (3.00) IS 3.00; CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.	3/23/2017	SM	JAG



SEE ATTACHED DEVIATION

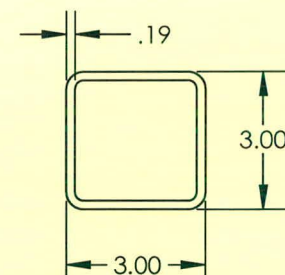
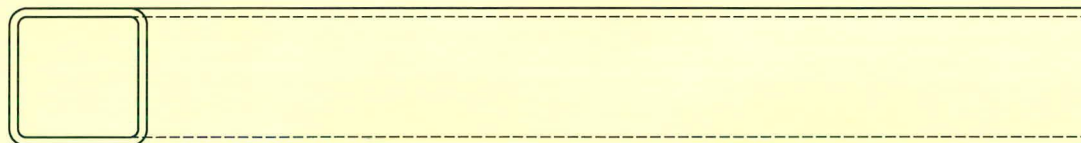
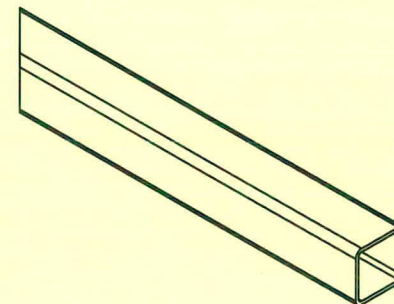
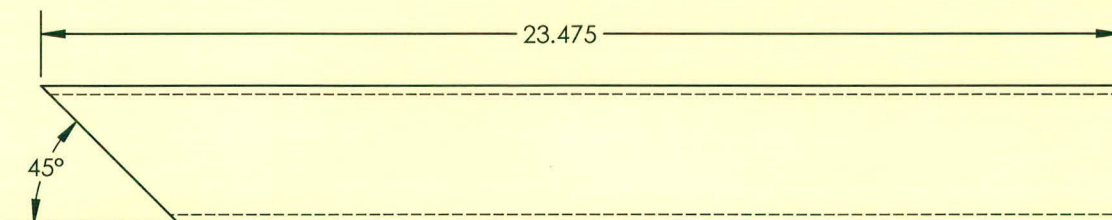
(-5)

LONG CENTER TUBE

DART AEROSPACE	
TITLE MULTI-PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-5	REV 5
MAT'L STEEL	
HEAT TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
DRAWN BY: CLOUGH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/✓
CHECKED: DD 03/23/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPS APPR: AA 07/24/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: JL 07/24/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: JAG 07/25/2017	USED ON MODEL AW139
SCALE 1:4	DATE 12/10/2012
SHEET 4 OF 20	

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
5	17-0072	-7 CH'D DIM WAS (.188) IS .19, WAS (3.00) IS 3.00, WAS (3.00) IS 3.00; CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.			3/23/2017	SM	JAG



SEE ATTACHED DEVIATION



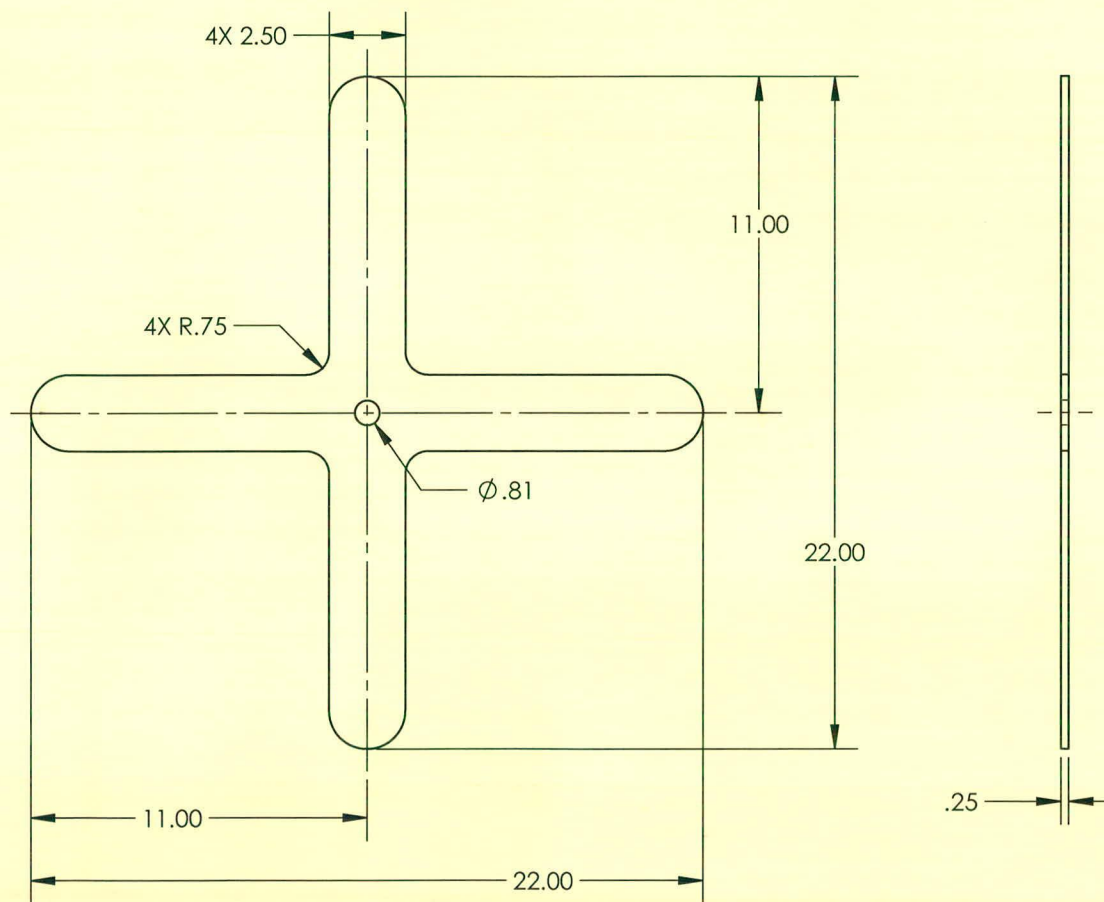
TITLE		MULTI-PURPOSE TROLLEY	
DWG NO.		RBW6005G00131-3G-7	
REV		5	
MAT'L STEEL		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -1 WELDMENT		XXX ± .010 FRACTIONS ± 1/8	
SPEC		XX ± .03 ANGLES ± 1°	
		X ± .1 SURFACES = 125/✓	
DRAWN BY: CLOUGH		1. BREAK ALL SHARP EDGES	
CHECKED: DD 03/23/2017		.015 x 45° OR .016R	
OPPS APPR: AA 07/24/2017		2. DIMENSIONAL LIMITS APPLY	
QA APPR: JL 07/24/2017		AFTER PLATING	
APPROVED: JAG 07/25/2017		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:4		DATE 12/10/2012	
		SHEET 5 OF 20	

(-7)

CENTER SHORT TUBE

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		CH'D -9 DESIGN TO MAKE LIGHTER AND COLLAPSIBLE & DELETED -11 CONFIGURATION OF -9.	1/17/2013	RJC	DW
4		-9 CH'D HOLE FOR POWDER COATING CLEARANCE WAS Ø.797 IS .81.	10/10/2013	CFS	GE
5	17-0072	-9 CH'D DIM WAS (.250) IS .25; CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.	3/23/2017	SM	JAG



(-9)

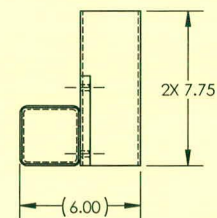
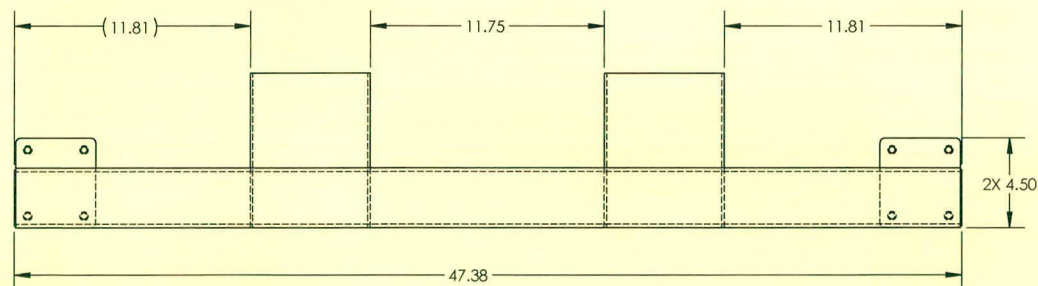
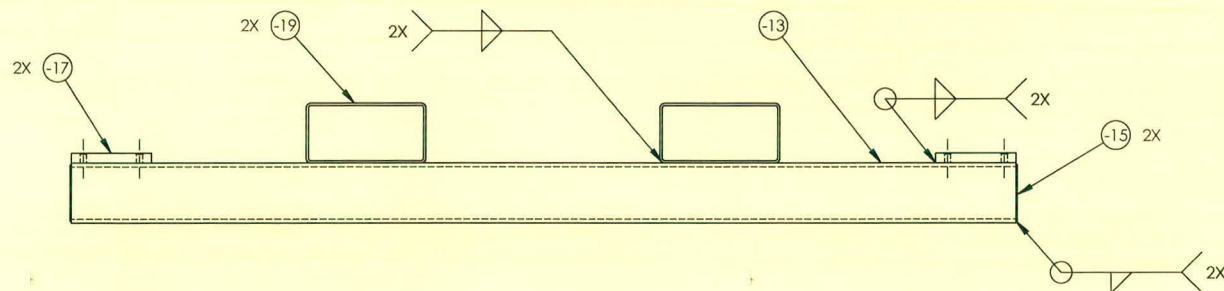
DOUBLER PLATE

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MUTLIPURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-9	REV 5
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE - 1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DD 03/23/2017	.015 x 45° OR .015R
OPPS APPR: AA 07/24/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 07/24/2017	AFTER PLATING
APPROVED: JAG 07/25/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:6	USED ON MODEL
DATE 12/10/2012	AW139
SHEET 6 OF 20	

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
2		MADE SEPARATE -11 WELDMENT.		1/17/2013	RJC	DW
5	17-0072	-11 CH'D DIM WAS 11.81 IS (11.81); REMOVED DIM 4.00; CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.		3/23/2017	SM	JAG



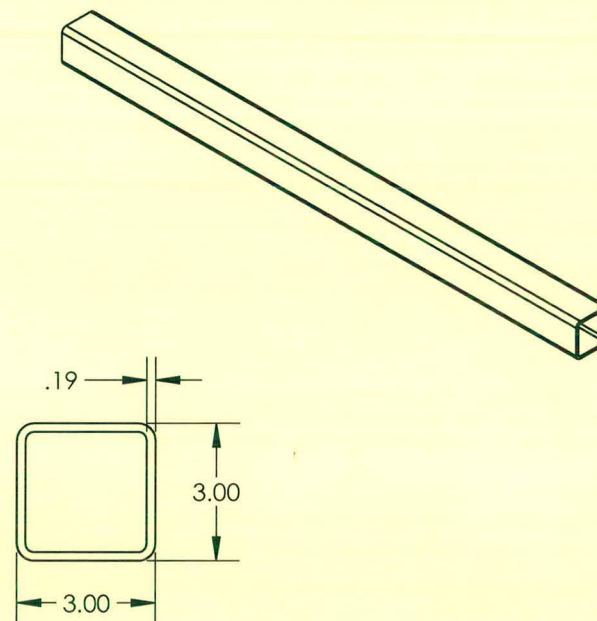
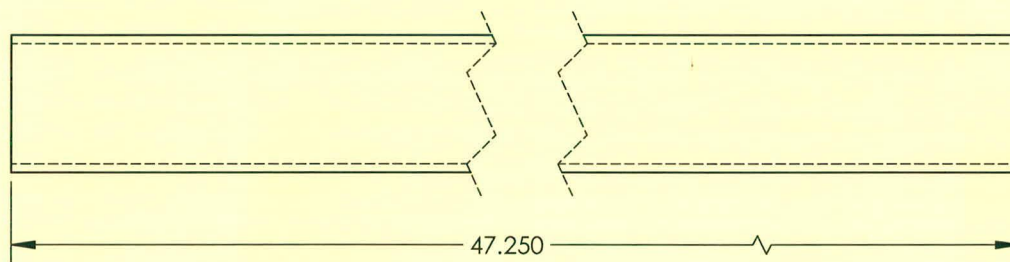
(11)
SIDE WELDMENT

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MULTI-PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-11	REV 5
MAT'L FINISH SEE -1 WELDMENT SPEC DRAWN BY: CLOUGH CHECKED: DD 03/23/2017 OP'S APPR: AA 07/24/2017 QA APPR: JL 07/24/2017 APPROVED: JAG 07/25/2017	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES ± 125/ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL AW139	
SCALE 1:6	DATE 12/10/2012
SHEET 7 OF 20	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	17-0072	-13 CH'D DIM WAS (.188) IS .19, WAS (3.00) IS 3.00, WAS (3.00) IS 3.00; CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.	3/23/2017	SM	JAG



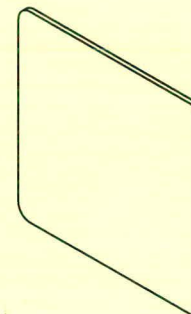
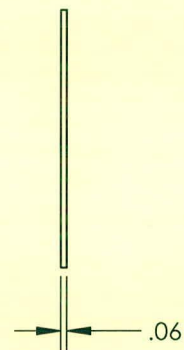
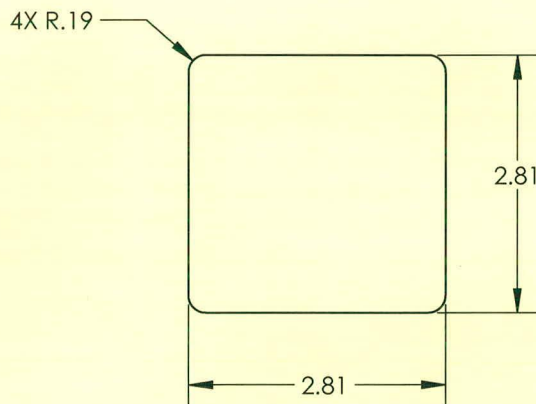
SEE ATTACHED DEVIATION

(-13)
SIDE TUBE

DART AEROSPACE																	
TITLE MULTI-PURPOSE TROLLEY																	
DWG NO. RBW6005G00131-3G-13	REV 5																
<table border="1"> <tr> <td>MAT'L STEEL</td> <td rowspan="5"> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 </td> </tr> <tr> <td>HEAT TREAT</td> </tr> <tr> <td>FINISH SEE -1 WELDMENT</td> </tr> <tr> <td>SPEC</td> </tr> <tr> <td>DRAWN BY: CLOUGH</td> </tr> <tr> <td>CHECKED: DD 03/23/2017</td> <td>USED ON MODEL</td> </tr> <tr> <td>OPPS APPR: AA 07/24/2017</td> <td>AGUSTA AW139</td> </tr> <tr> <td>QA APPR: JL 07/24/2017</td> <td></td> </tr> <tr> <td>APPROVED: JAG 07/25/2017</td> <td></td> </tr> <tr> <td>SCALE 1:4</td> <td>DATE 12/10/2012 SHEET 8 OF 20</td> </tr> </table>		MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	HEAT TREAT	FINISH SEE -1 WELDMENT	SPEC	DRAWN BY: CLOUGH	CHECKED: DD 03/23/2017	USED ON MODEL	OPPS APPR: AA 07/24/2017	AGUSTA AW139	QA APPR: JL 07/24/2017		APPROVED: JAG 07/25/2017		SCALE 1:4	DATE 12/10/2012 SHEET 8 OF 20
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009																
HEAT TREAT																	
FINISH SEE -1 WELDMENT																	
SPEC																	
DRAWN BY: CLOUGH																	
CHECKED: DD 03/23/2017	USED ON MODEL																
OPPS APPR: AA 07/24/2017	AGUSTA AW139																
QA APPR: JL 07/24/2017																	
APPROVED: JAG 07/25/2017																	
SCALE 1:4	DATE 12/10/2012 SHEET 8 OF 20																

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		-15 CH'D DIM. PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS.	10/10/2013	CFS	GE
5	17-0072	-15 CH'D DIM WAS (.06) IS .07; CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.	3/23/2017	SM	JAG



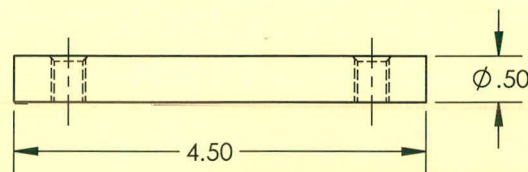
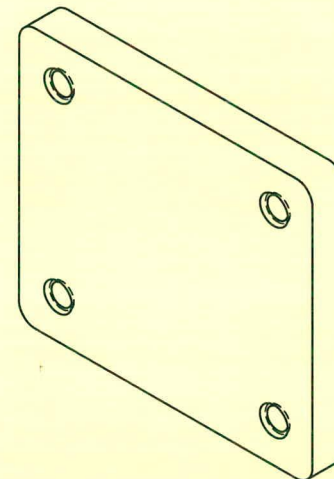
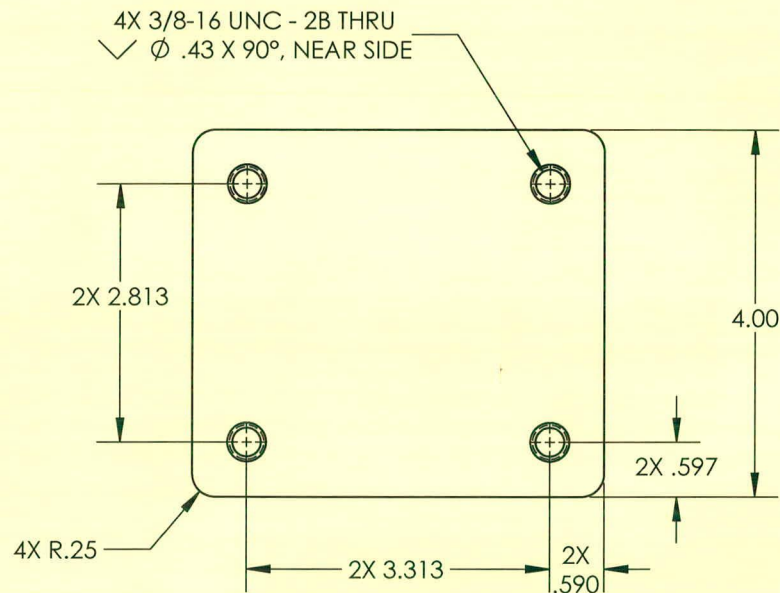
(-15)
END CAP

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MULTI-PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-15	REV 5
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 03/23/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/24/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/25/2017	AW139
SCALE 1:2	DATE 12/10/2012 SHEET 9 OF 20

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
5	17-0072	-17 CH'D DIM WAS 4X 3/8-16 UNC THRU IS 4X 3/8-16 UNC-2B THRU, WAS (Ø.50) IS Ø.50; CH'D MAT'L WAS 1018 IS 1018/1020 CR; CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.			3/23/2017	SM JAG



(-17)

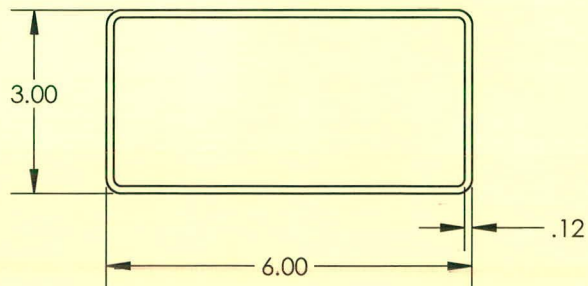
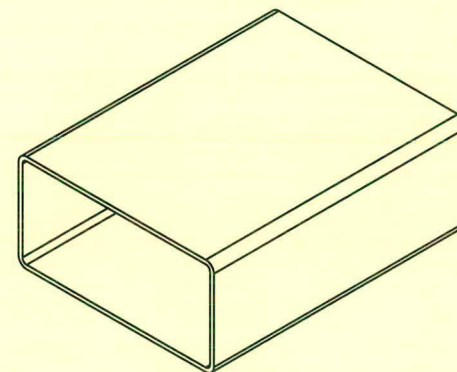
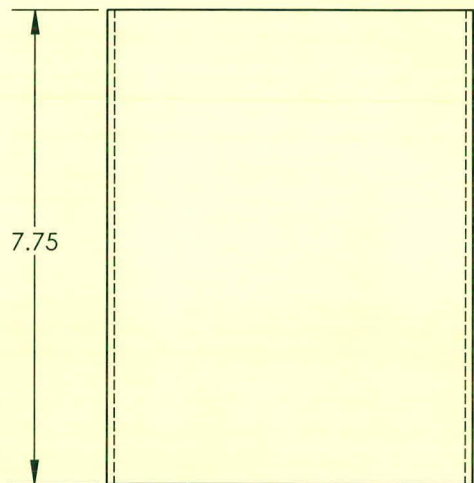
WHEEL PLATE

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MULTI-PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-17	REV 5
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
CHECKED: DD 03/23/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/24/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/25/2017	AW139
SCALE 1:2	DATE 12/10/2012 SHEET 10 OF 20

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	17-0072	-19 CH'D DIM WAS (3.00) IS 3.00, WAS (6.00) IS 6.00, WAS (.120) IS .12; CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.	3/23/2017	SM	JAG



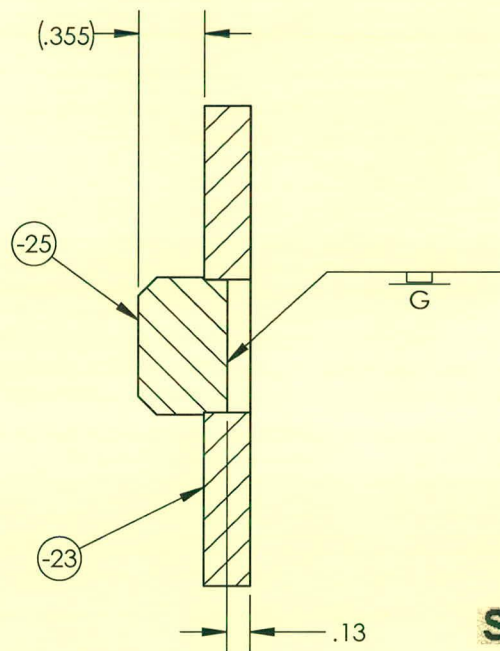
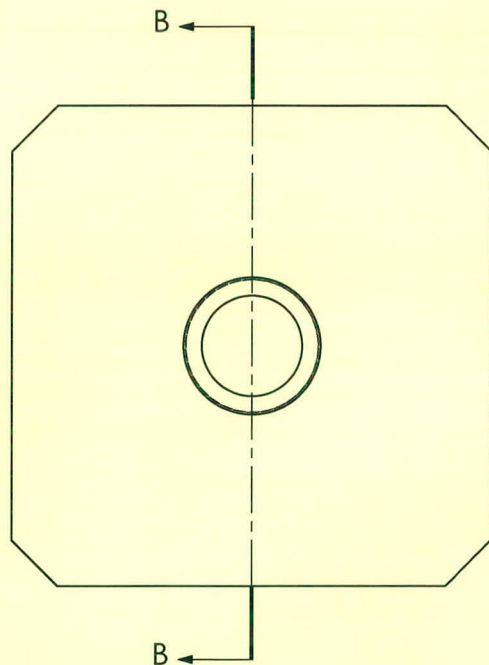
(-19)
FORK TUBE

SEE ATTACHED DEVIATION

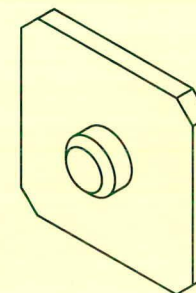
DART AEROSPACE	
TITLE MULTI-PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-19	REV 5
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 03/23/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/24/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/25/2017	AW139
SCALE 1:3	DATE 12/10/2012
SHEET 11 OF 20	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
4		-21 REMOVED NOTE TO TAPE BEFORE POWDER COAT.	10/10/2013	CFS
5	17-0072	-21 CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.	3/23/2017	SM



SECTION B-B



SEE ATTACHED DEVIATION

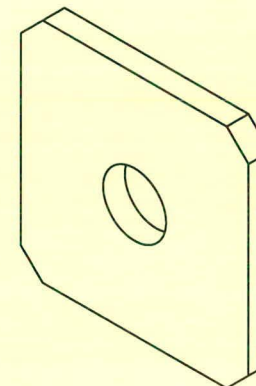
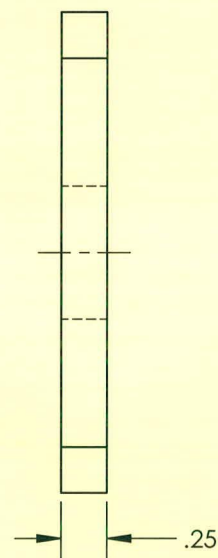
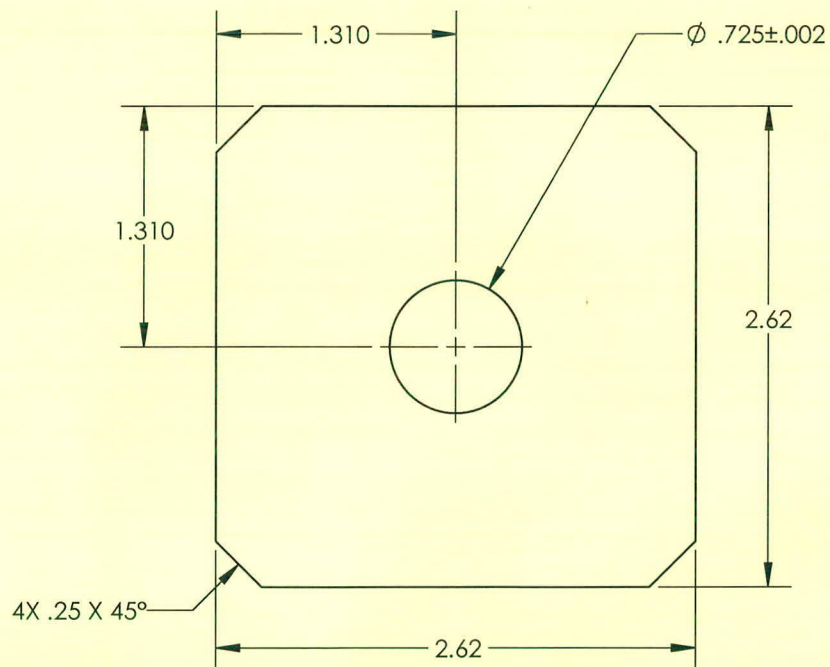
DART AEROSPACE	
TITLE MULTI-PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-21	REV 5
MAT'L HEAT TREAT FINISH SEE -27 WELDMENT SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 03/23/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/24/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/25/2017	AW139
SCALE 1:1	DATE 12/10/2012

(-21)

ALIGNMENT PLATE WELDMENT

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		CH'D -23 HOLE FROM Ø.797.	1/17/2013	RJC	SE
4		-23 CH'D DIM. PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS.	10/10/2013	CFS	GE
5	17-0072	-23 CH'D DIM WAS (.250) IS .25; CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.	3/23/2017	SM	JAG



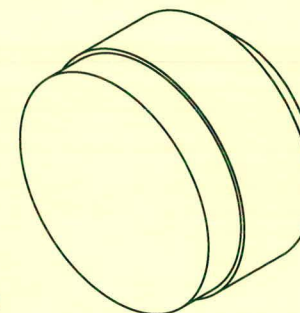
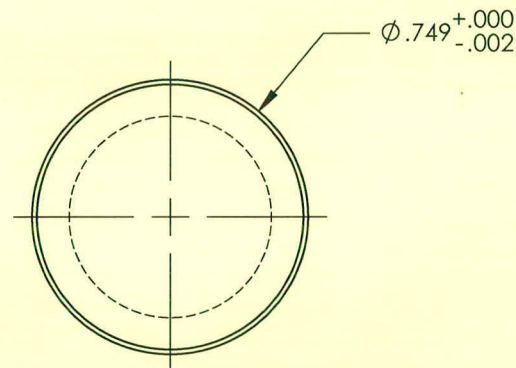
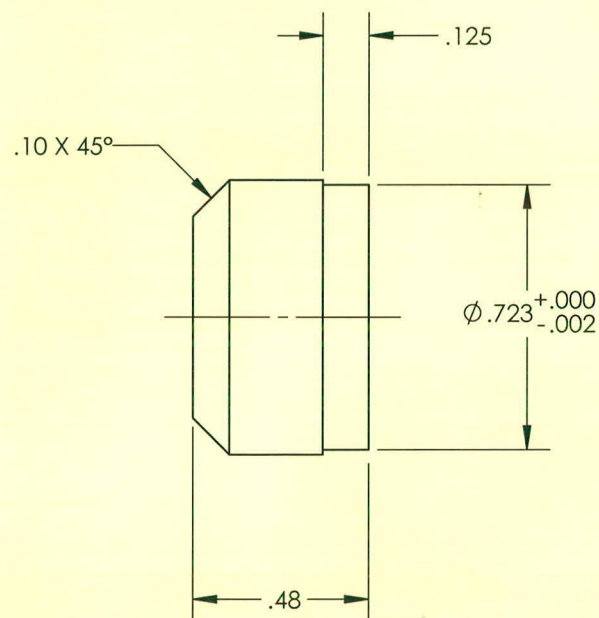
SEE ATTACHED DEVIATION

(-23)
ALIGNMENT PLATE

DART AEROSPACE	
TITLE MULTI-PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-23	REV 5
MAT'L 1018	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -27 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 03/23/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/24/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/25/2017	AW139
SCALE 1:1	DATE 12/10/2012 SHEET 13 OF 20

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		CH'D -25 DESIGN, ADDED $\phi .723 +.000-.002$ FEATURE TO SLIP FIT -23 FOR PLUG WELD.	1/17/2013	RJC	SE
5	17-0072	-25 CH'D MAT'L WAS 1081 IS 1018/1020 CR; CH'D DIM WAS .480 is .48.	3/23/2017	SM	JAG



SEE ATTACHED DEVIATION

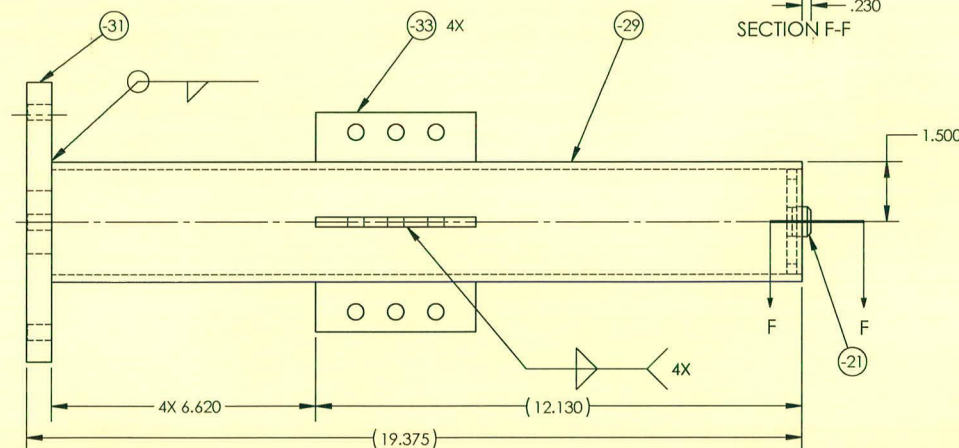
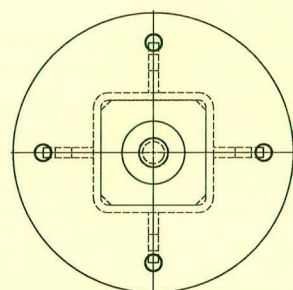
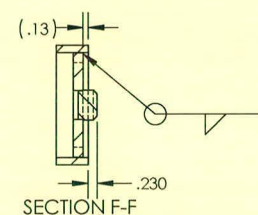
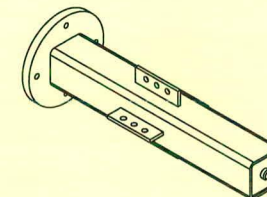
(25)

ALIGNMENT PIN

DART AEROSPACE	
TITLE MULTIPURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-25	REV 5
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm .005$ FRACTIONS $\pm 1/8$
FINISH SEE -27 WELDMENT	.XX $\pm .01$ ANGLES $\pm 5^\circ$
SPEC	.X $\pm .1$ SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 03/23/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/24/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/25/2017	AW139
SCALE 2:1	DATE 12/10/2012 SHEET 14 OF 20

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
5	17-0072	-27 CHD DIM WAS .13 IS (.13); CHD TOL WAS .XXX±.005/XX±.01 IS .XXX±.010/XX±.03.		3/23/2017	SM	JAG



(-27)

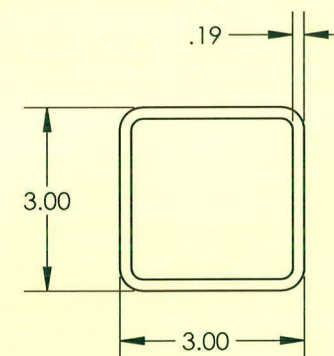
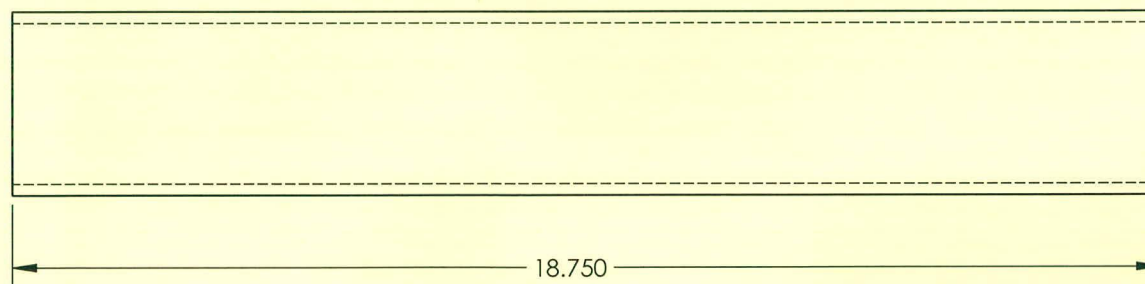
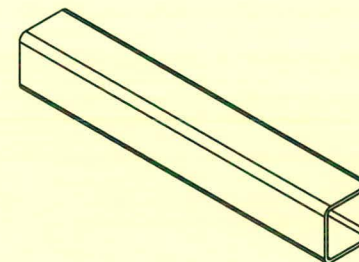
UPRIGHT WELDMENT

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MULTI-PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-27	REV 5
MAT'L 6061-T6	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH POWDER COAT YELLOW	.XX ± .03 ANGLES ± 1°
SPEC FED #1353B	.X ± .1 SURFACES = 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED BY: DD 03/23/2017	.015 x 45° OR .015R
OPPS APPR: AA 07/24/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 07/24/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED BY: JAG 07/25/2017	USED ON MODEL AW139
SCALE 1:3	DATE 12/10/2012
SHEET 15 OF 20	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	17-0072	-29 CH'D DIM WAS (.188) IS .19, WAS (3.00) IS 3.00, WAS (3.00) IS 3.00; CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.	3/23/2017	SM	JAG



SEE ATTACHED DEVIATION

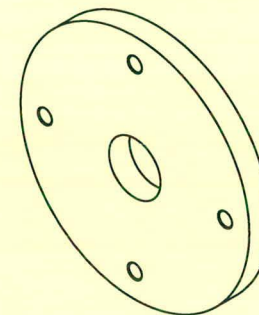
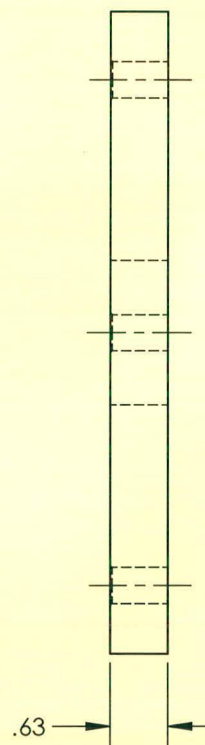
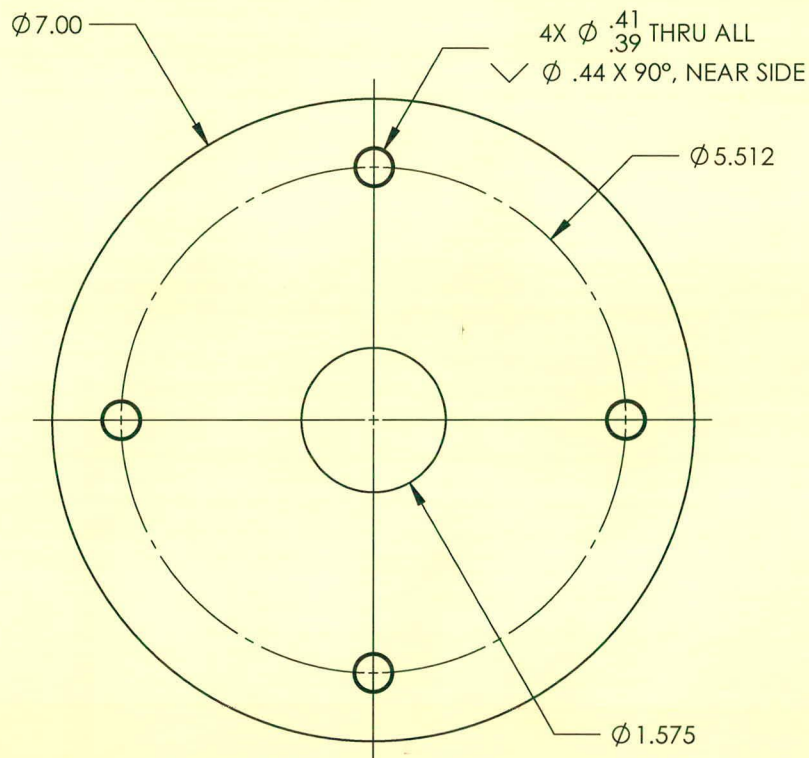
(-29)

VERTICAL TUBE

DART AEROSPACE	
TITLE MULTIPURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-29	REV 5
MAT'L STEEL HEAT TREAT FINISH SEE -27 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: DD 03/23/2017	AW139
OPPS APPR: AA 07/24/2017	
QA APPR: JL 07/24/2017	
APPROVED: JAG 07/25/2017	
SCALE 1:3	DATE 12/10/2012
SHEET 16 OF 20	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		-31 CH'D OD WAS Ø6.850 IS Ø7.000, CH'D BOLT CIRCLE WAS Ø5.375 IS Ø5.512, CH'D CENTER HOLE WAS Ø1.560 IS Ø1.575.	7/10/2013	RJC	DW
4		-31 CH'D HOLE TOLERANCE WAS 4X Ø.386 IS 4X Ø.41-Ø.39, CH'D TOLERANCE OF OD WAS (Ø7.000) IS Ø7.00.	10/10/2013	CFS	GE
5	17-0072	-31 CH'D DIM WAS (.625) IS .63.	3/23/2017	SM	JAG



(-31)

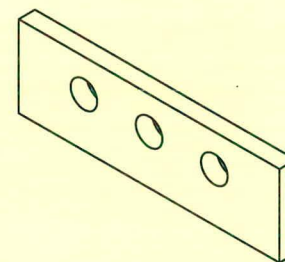
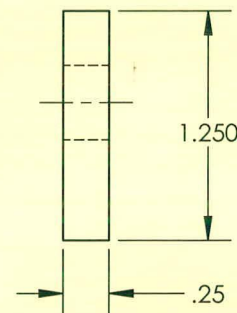
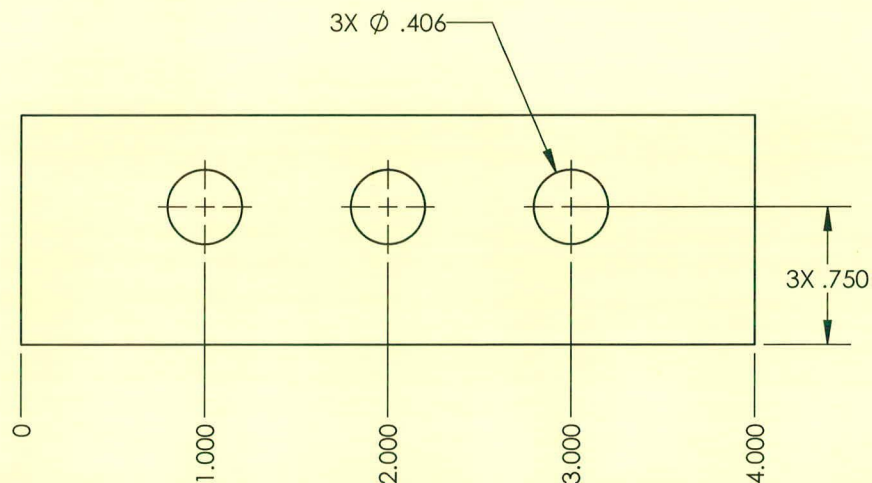
TOP PLATE

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MULTI-PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-31	REV 5
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -27 WELDMENT	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 03/23/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/24/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/25/2017	AW139
SCALE 1:2	DATE 12/10/2012
SHEET 17 OF 20	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		CH'D -33 OVERALL LENGTH FROM 5.280 AND ADJUSTED HOLE PLACEMENT.	1/17/2013	RJC	DW
5	17-0072	-33 CH'D DIM WAS (.250) IS .25; CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.	3/23/2017	SM	JAG



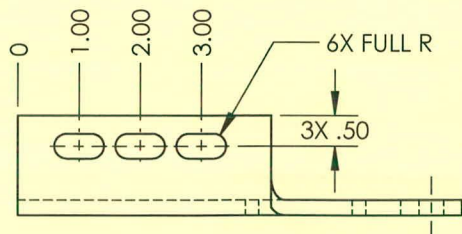
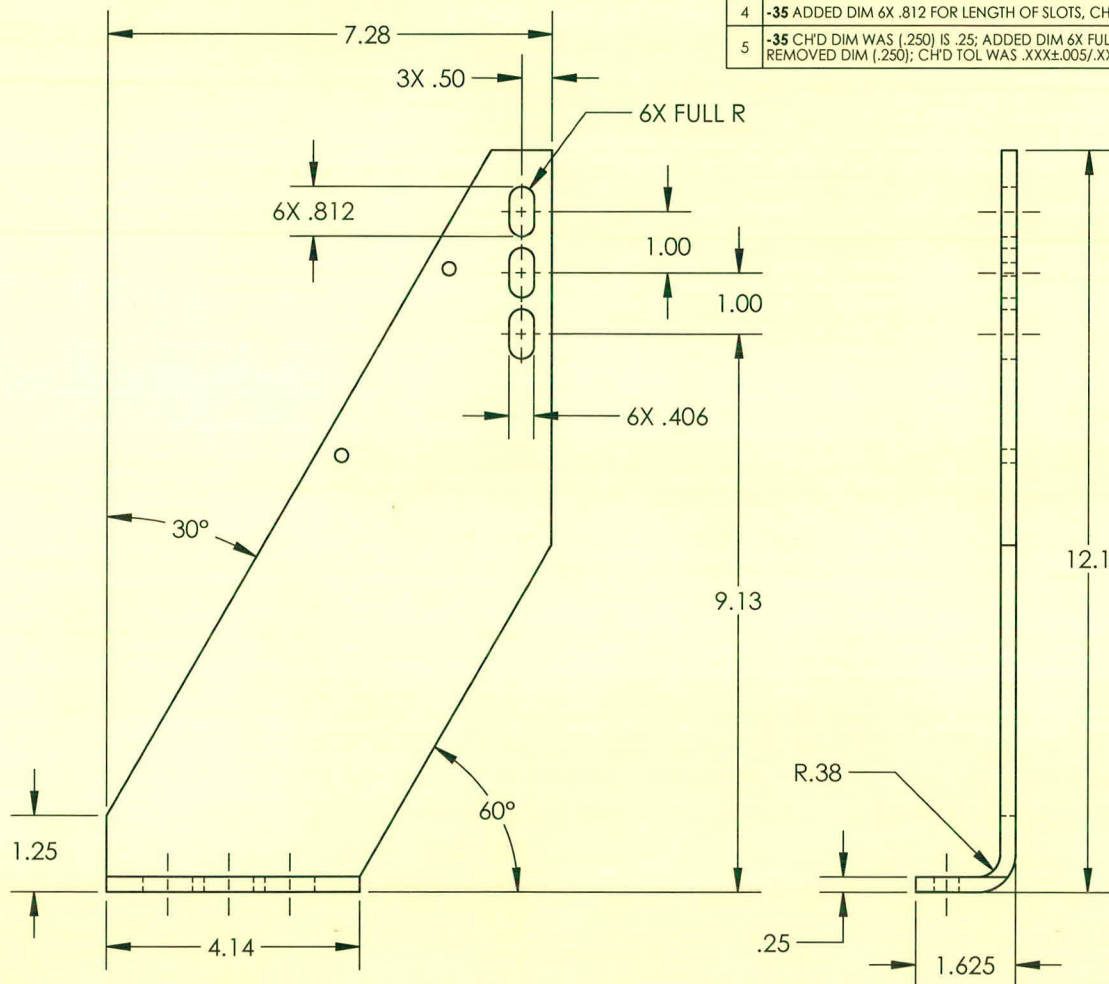
SEE ATTACHED DEVIATION

(-33)
PLATE

DART AEROSPACE	
TITLE MULTI PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-33	REV. 5
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -27 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 03/23/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/24/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/25/2017	AW139
SCALE 1:1	DATE 12/10/2012 SHEET 18 OF 20

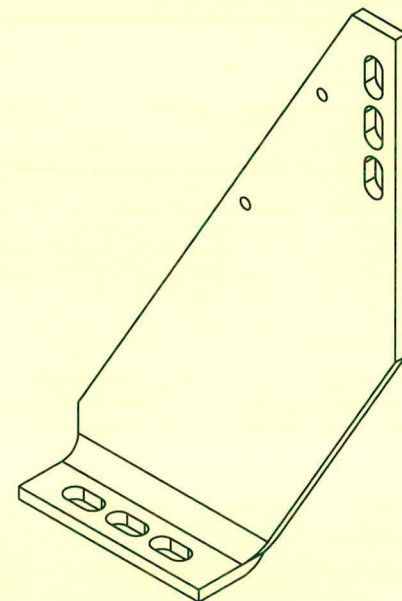
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	REDESIGNED -35 GUSSET TO BE COLLAPSIBLE.	1/17/2013	RJC	DW
2A	-35 CH'D DIM. SCHEME CORRECTED MODEL PER G.E. CH'D DIM. WAS 4.00 IS 4.14.	4/1/2013	BIM	GE
4	-35 ADDED DIM 6X .812 FOR LENGTH OF SLOTS, CH'D SLOT WIDTH DIM. WAS 3X .406 IS 6X .406	10/11/2013	CF5	GE
5	-35 CH'D DIM WAS (.250) IS .25; ADDED DIM 6X FULL R; CH'D MAT'L WAS A36 P&O IS A36/1018/1020 HR; REMOVED DIM (.250); CH'D TOL WAS .XXX±.005/.XX±.01 IS .XXX±.010/.XX±.03.	3/23/2017	SM	JAG



(-35)

GUSSET

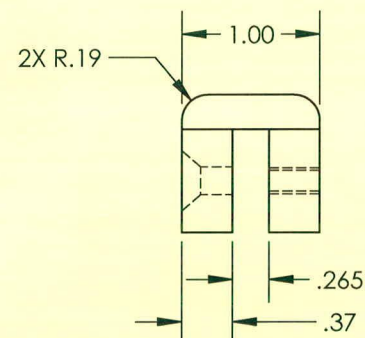
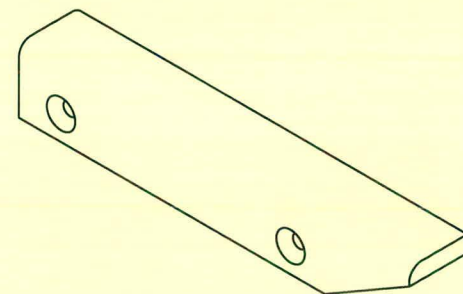
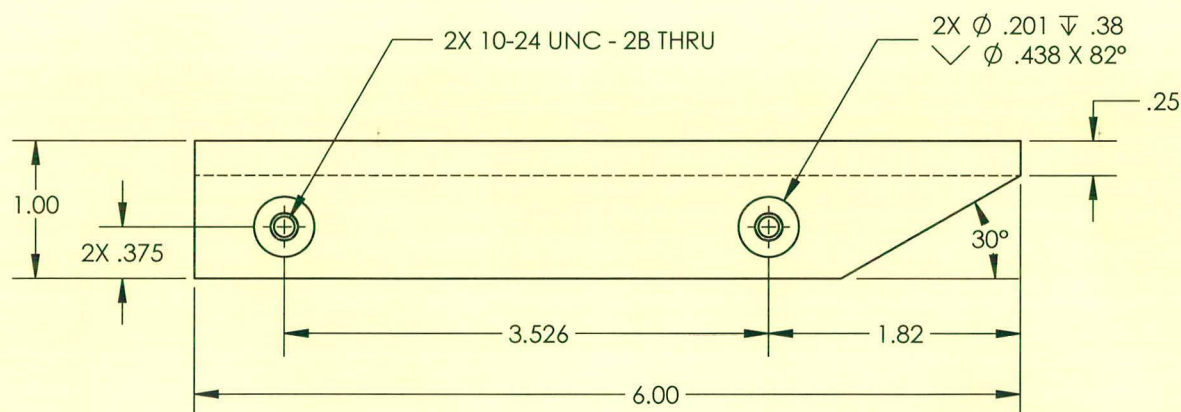


SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MULTIPURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-35	REV. 5
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH POWDER COAT YELLOW	.XX ± .03 ANGLES ± 1°
SPEC FED #13538	.X ± .1 SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 03/23/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/24/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/25/2017	AW139
SCALE 1:3	DATE 1/3/2013
SHEET 19 OF 20	

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
5	17-0072	-36 ADDED.			3/22/2017	SM	JAG



SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MULTI-PURPOSE TROLLEY	
DWG NO. RBW6005G00131-3G-36	REV 5
MAT'L WHITE DELRIN/ACETAL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX $\pm$.010 FRACTIONS $\pm$ 1/8
TREAT	.XX $\pm$.03 ANGLES $\pm$ 1°
FINISH	.X $\pm$.1 SURFACES = 125 $\checkmark$
SPEC	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DD 03/23/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 07/24/2017	USED ON MODEL
QA APPR: JL 07/24/2017	AW139
APPROVED: JAG 07/25/2017	
SCALE 3:4	DATE 3/22/2017 SHEET 20 OF 20

(-36)

PROTECTOR

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. <u>RBW6005G00131-3G Rev. 5</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) JULY 23, 2018	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator	
- RBW6005G00131-3G- 9 (McMaster 91251A626, 3/8"-16 x1.25) must be replaced with McMaster 91251A626 (3/8"-16 x1.5)		This deviation is acceptable. The longer bolt will allow the trolley to be used with multiple attachments			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041059**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041059
PO Date: 9/18/18
Due Date: 10/23/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183513	RBW6005G00131-3GP			Multi-Purpose Trolley REV 5	Firmed	-	10/23/18	1 pcs	0 pcs	1 pcs	\$3,205.00/pcs	\$3,205.00
Line Item Note ** RUSH OCT 23,2018 **													
2	183514	RBW6005G00131-3GP			Multi-Purpose Trolley REV 5	Firmed	-	10/23/18	1 pcs	0 pcs	1 pcs	\$3,205.00/pcs	\$3,205.00
Line Item Note ** RUSH OCT 23,2018 **													
3	183515	RBW6005G00131-3GP			Multi-Purpose Trolley REV 5	Firmed	-	11/20/18	1 pcs	0 pcs	1 pcs	\$3,205.00/pcs	\$3,205.00
Line Item Note ** CONSIGNMENT / KEEP AT METEC **													
4	183517	RBW6005G00131-3GP			Multi-Purpose Trolley REV 5	Firmed	-	11/20/18	1 pcs	0 pcs	1 pcs	\$3,205.00/pcs	\$3,205.00
Line Item Note ** CONSIGNMENT / KEEP AT METEC **													
Grand Total:												\$12,820.00	

DAS
68
9-89

2AQ
88
98-9



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO041059

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in black ink, appearing to be "Plex", located to the right of the Order Notes section.

Plex 10/23/18 4:15 PM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24265
Shipment Date: 20-Nov-2018
Ship Via: YOUR TRUCK
Order Number: 3030
Order Date: 09/18/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041059
Terms: Net 60 Days

----- Quantity -----								Job
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>
1	2	2	0	0	EA	DART-RBW6005G00131-3GP MULTI-PURPOSE TROLLEY		3030-01

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
2	DART-RBW6005G00131- 3GP	MULTI-PURPOSE TROLLEY	7	41059

DAS
68
9-89

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


George Theoret

Vankleek Hill, November 20, 2018

11

83
10-10